

Work Order ID 93200 -2

November-15-12 9:22:19 AM

\*93200\*

Page 1

Item ID: D4434-043

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Fwd inboard Bracket Assembly

Start Date: 11/15/12 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 11/30/12 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12-11-16 Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4434

B

100

0.00

\*100\*

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut D4434-1 as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

10

8

Jm 12-11-30

10

0

Jm 12-11-30



# Work Order ID 93200

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\*93200\*

Page 2

Item ID: D4434-043

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Fwd inboard Bracket Assembly

Start Date: 11/15/12 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 11/30/12 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop \*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Qty Reject Qty Reject Number Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

DAS  
15  
8-89

10

\*120\*

QC

Memo

0.00

12 11-30

Quality Control

130

Bend as per dwg

0.00

\*130\*

Brake NC

Memo

0.00

10

80  
12/12/03

Brake NC

150

QC5- Inspect part completeness to step on W/O

0.00

DAS  
15  
8-89

10

\*150\*

QC

Memo

0.00

12 12 03

Quality Control





# Work Order ID 93200

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Item ID: D4434-043 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Fwd inboard Bracket Assembly  
 Start Date: 11/15/12 Start Qty: 6.00 \*6\* Cust Item ID:  
 Required Date: 11/30/12 Req'd Qty: 6.00 \*6\* Customer:

## Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				10 X			MJ 12/12/03
170 *170* QC Quality Control	QC7-Inspect Chemical Conversion Coat  Memo	0.00 0.00				10			AS 15 9-83 12 12 03
180 *180* Small Fab Small Fab	1-C'sink as per dwg. 2-Assemble as per dwg, do not install grommets and rubber seal.	0.00 0.00				3x 3			12/12/04 FF 12-12-04



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Page 4

Item ID: D4434-043 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Fwd inboard Bracket Assembly  
 Start Date: 11/15/12 Start Qty: 6.00 \*6\* Cust Item ID:  
 Required Date: 11/30/12 Req'd Qty: 6.00 \*6\* Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
185 *185* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00				3			
	Memo	0.00							
190 *190* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
	Memo	0.00							
	*** MASK NUT PLATE HOLES PER DWG ***								
	START TIME: 8:30								
	OVEN TEMPERATURE: 3200 F								
	FINISH TIME: 9:00								
200 *200* QC Quality Control	QC3- Inspect Part Finish	0.00							
	Memo	0.00							

m121279

3X4 m/L 12/12/05

34 12-12-5 200





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Page 5

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

**Item Name:** Fwd inboard Bracket Assembly

**Start Date:** 11/15/12      **Start Qty:** 6.00

\*6\*

Cust Item ID:

**Required Date:** 11/30/12      **Req'd Qty:** 6.00

\*6\*

**Customer:**

**Reference:**

Run Start \*NR1\*

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

### Operation Description

### Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

202

0.00

\*202\*

0.00

### Small Fab

## Memo

Install rubber seals and grommets.

3M 1300 batch: 123 676

205

QC5- Inspect part completeness to step on W/O	0.00
-----------------------------------------------	------

0.00

\*205\*

0.00

QC

## Memo

### Quality Control

210

Identify as per dwg & Stock Location: GA 0.00

0.00

\*210\*

0.00

### Packaging

## Memo

### Packaging

100

Work Order ID 93200

\*93200\*

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November-15-12 9:22:19 AM

Item ID: D4434-043 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Fwd inboard Bracket Assembly  
Start Date: 11/15/12 Start Qty: 6.00 \*6\* Cust Item ID:  
Required Date: 11/30/12 Req'd Qty: 6.00 \*6\* Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC21- Final Inspection - Work Order Release	0.00							
*220*									
QC	Memo	0.00							
Quality Control									

12/12/12





# Picklist Print

November-15-12 9:22:18 AM

Page 1

Work Order ID: 93200

Parent Item: D4434-043

Parent Item Name: Fwd inboard Bracket Assembly

Start Date: 11/15/12

Required Date: 11/30/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP revA 11.10.06 new issue EC verified by:DD IPP RevB 11.12.22 per PA5  
EC verified by:JLM IPP RevC 12.01.24 per REV.A DD verified by:EC  
IPP RevD 12.03.05 per REV.B DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040 6061-T6 .040 Sheet		Purchased	No			100	sf	156.6578	2.5	15.789473 25			Jm 12-11-30
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT021		156.6578							
				121099		156.6578							
				123874									
D4434-9 Bracket		Manufactured	No			180	Each	5.0000	1	6			FF 12-12-04
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		5		B 93372					
				80675		1							
				83906		4							
D4435-041 Bracket Assembly		Manufactured	No			180	Each	11.0000	1	6			FF 12-12-04 FF 12-12-06
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST109		10							
				83473		10							
				ST441		1							
				80678		1							
D4441-1 Rubber Seal		Manufactured	No			202	f	651.1146	0.142	0.852			FF 12-12-06
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST412		651.1146							
				74760		6.119							
				79385		0.0476							
				80763		159.54							
				86185		485.408							
										0.284			



# Picklist Print

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Page 2

Work Order ID: 93200

Parent Item: D4434-043

Parent Item Name: Fwd inboard Bracket Assembly

Start Date: 11/15/12

Required Date: 11/30/12

Start Qty: 6.00

Required Qty: 6.00

D4441-1      Manufactured      No      f      651.1146      1.248      FF 12-12-06  
Rubber Seal

Location	Loc Qty	Loc Code
ST412	651.1146	
74760	6.119	
79385	0.0476	
<u>80763</u>	159.54	
86185	485.408	

0.624

D4441-1      Manufactured      No      f      651.1146      11.25      FF 12-12-06  
Rubber Seal

Location	Loc Qty	Loc Code
ST412	651.1146	
74760	6.119	
79385	0.0476	
<u>80763</u>	159.54	
86185	485.408	

3.75

D4440-1      Manufactured      No      202      Each      86.0000      1      6      FF 12-12-06  
Grommet

Location	Loc Qty	Loc Code
GA	83	
80645	23	
<u>91714</u>	60	
prelim	2	
74759	2	
ST139F	1	
79372	1	

3

AN525-832R6      Purchased      No      180      Each      84.0000      3      18      FF 12-12-06  
Screw

Location	Loc Qty	Loc Code
ST345	84	
120308	1	
<u>120560</u>	83	

19

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Shop Packet Print

Page 2





# Picklist Print

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Page 3

Work Order ID: 93200

Parent Item: D4434-043


Parent Item Name: Fwd inboard Bracket Assembly

Start Date: 11/15/12

Required Date: 11/30/12

Start Qty: 6.00

Required Qty: 6.00

MS20426AD3-3 <sup>3</sup>  Purchased No 180 Each 18,159.000 12 72 FF 12-12-04

Rivet

Location	Loc Qty	Loc Code
Mezz 122814	18159	6
1173	8879	
13276	9280	

MS20426AD3-3

Purchased

No

180 Each 19,370.750 2 12

FF 12-12-04

Rivet

Location	Loc Qty	Loc Code
ST316	1470	
119109	282	
121011	771	
19099	417	
ST333	6250	
123352	6250	
ST334	11650.75	
122814	11650.75	36

MS20470AD4-3

Purchased

No

180 Each 5,185.0000 5 30

FF 12-12-04

Rivet - Universal Head

Location	Loc Qty	Loc Code
Mezz	5185	
1642	620	15
2193	4565	

MS21075L08

Purchased

No

180 Each 301.0000 7 42

FF 12-12-04

ANCHOR NUT

Location	Loc Qty	Loc Code
ST318	301	
103053	55	
111578	1	
120560	8	
120930	1	
121556	50	
123265	186	21

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Shop Packet Print

Page 3

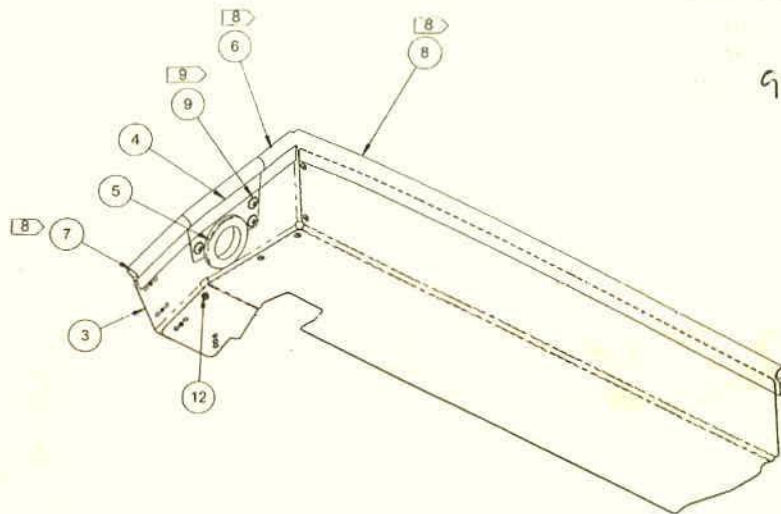




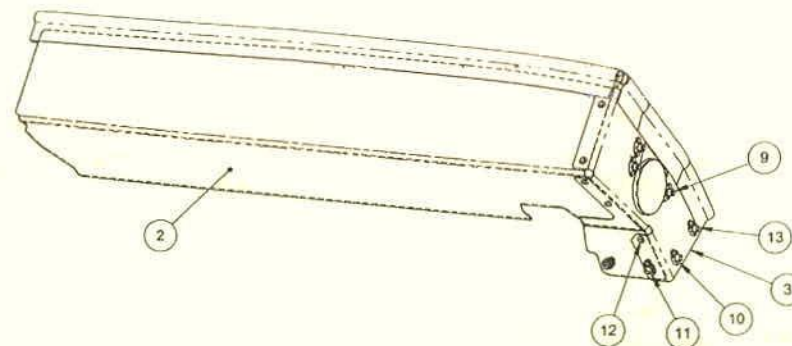








93200 MJS  
12-11-10



# **D4434-043 FWD INBOARD BRACKET ASSEMBLY**

RELEASED  
2012-03-02

## **NOTES:**

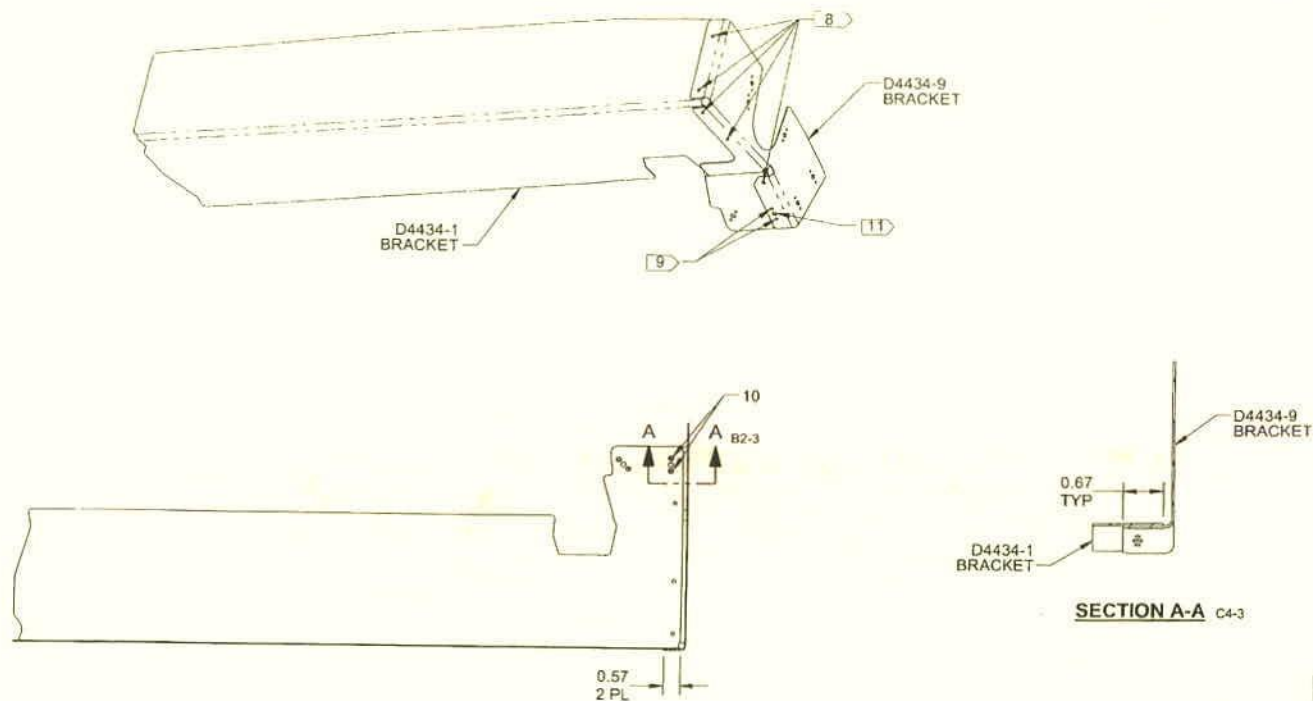
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3 MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING
- 9) TORQUE SCREW TO 12-15 (in-lb)

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4434-043	FWD INBOARD BRACKET ASSEMBLY
2	1	D4434-1	BRACKET
3	1	D4434-9	BRACKET
4	1	D4435-041	BRACKET ASSEMBLY
5	1	D4440-1	GROMMET
6	1	D4441-1-017	RUBBER SEAL
7	1	D4441-1-025	RUBBER SEAL
8	1	D4441-1-225	RUBBER SEAL
9	3	AN525-B32R6	SCREW
10	12	MS20426AD3-2	RIVET
11	2	MS20426AD3-3	RIVET
12	5	MS20470AD4-3	RIVET
13	7	MS21075L08	NUT PLATE
14	A/R	3M 1300/1300L	ADHESIVE

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	MP	DRAWING NO. <b>D4434</b>	REV. B
MFG. APPR.	BE	SHEET 2 OF 15	
APPROVED	MP	TITLE <b>COVER ASSEMBLY</b>	SCALE NTS
DE APPR.	MP	COPYRIGHT © 2012 BY DART AEROSPACE LTD. THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.02.22		



93200



**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs
- 8) TRANSFER  $\phi 0.129$  HOLES THRU 5 PLACES FROM D4434-9 TO D4434-1
- 9) TRANSFER  $\phi 0.098$  HOLES THRU 2 PLACES FROM D4434-9 TO D4434-1
- 10) CSK  $\phi 0.179 \times 100^\circ$  ON THIS SIDE 2 PLACES
- 11) TRANSFER  $\phi 0.177$  HOLE THRU FROM D4434-9 TO D4434-1

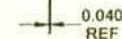
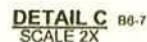
**D4434-043 FWD INBOARD BRACKET ASSEMBLY**  
AUXILIARY VIEW

RELEASED  
2012-05-03

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	<b>D4434</b>	SHEET 3 OF 15
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	<b>COVER ASSEMBLY</b>	NTS
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RELEASE  
2012-03-02

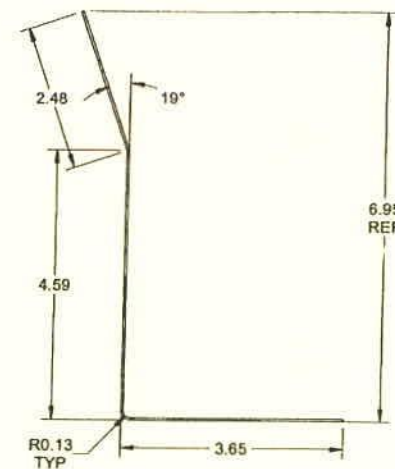
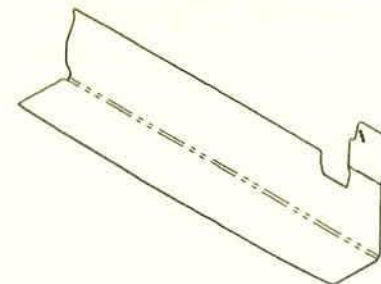
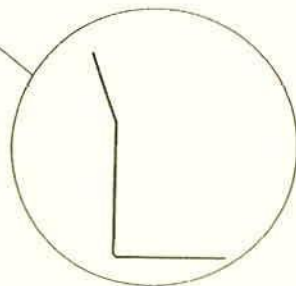
NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>10</i>	DRAWING NO.	REV. <i>1</i>
MFG. APPR.	<i>E</i>	<b>D4434</b>	SHEET 7 OF 7
APPROVED	<i>10</i>	TITLE	SCALE
DE APPR.	<i>10</i>	<b>COVER ASSEMBLY</b>	NTS
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B  
B2-6



**D4434-1 BRACKET**

**DETAIL B** CB-6  
SCALE 2X

**NOTES:**

- 1) MATERIAL: MAKE FROM D4434-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

**RELEASED**  
2012-03-02

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	E	<b>D4434</b>	SHEET 6 OF 15
APPROVED	140	TITLE	SCALE
DE APPR.	140	<b>COVER ASSEMBLY</b>	NTS
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